

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	TUBE
Job Number	:	31019			
Estimate Number	:	12773			
P.O. Number	:	N/A	Part Number	:	41232 200 002 001
This Issue	:	3/5/2007 S.O. No. : N/A	Drawing Number	:	41232-200-002 REV A
Prsht Rev.	:	NC	Project Number	:	N/A
First Issue	:	N/A Type : MACHINED PARTS	Drawing Revision	:	A
Previous Run	:	N/A	Material	:	N/A
Written By	:	<u>[Signature]</u>	Due Date	:	3/30/2007 Qty: 13 Um: Each
Checked & Approved By	:	<u>[Signature] 07.03.06</u>			
Comment	:	Est Rev:A New Issue 07-03-05 JLM			

Job Number:

Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3H1375	2024-T3 Hex Bar 1.375"
-----	--------------	------------------------

Comment: Qty.: 0.4550 f(s)/Unit Total : 5.4596 f(s)
2024-T3 Hex Bar 1.375"
Batch: M103753

20	LATHE CONV.	CONVENTIONAL LATHE
----	-------------	--------------------

Comment: CONVENTIONAL LATHE
Turn as per Dwg 41232-200-0021

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
-----	---------------	------------------------------

Comment: CONVENTIONAL MILLING MACHINE
Mill as per Dwg 41232-200-002

2-Debut

5.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0 QC8 SECOND CHECK

Comment: SECOND CHECK

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 3/5/2007 4:23:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE

Job Number: 31019

Part Number: 41232 200 002 001

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

OUTSIDE SERVICE

OUTSIDE SERVICES



Comment: Sub-Contracting PURCHASING

Issue P/O: 3360

Black Anodize as per Dwg 41232-200-005

Ensure Certificate of Conformity is attached

CD 07/03/20

(13)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

CD 07/03/27 (13)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 07 10 4/03 (13)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

G A T O O R

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07 10 4/13

Job Completion

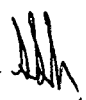
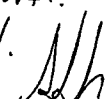

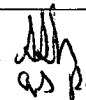
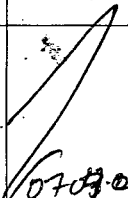


U 07 04-13

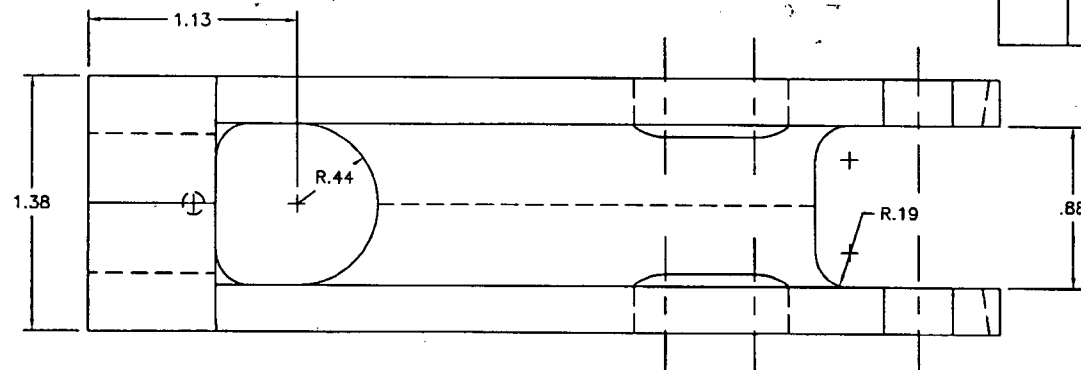
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

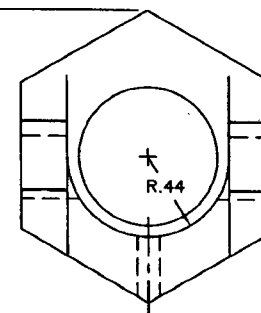
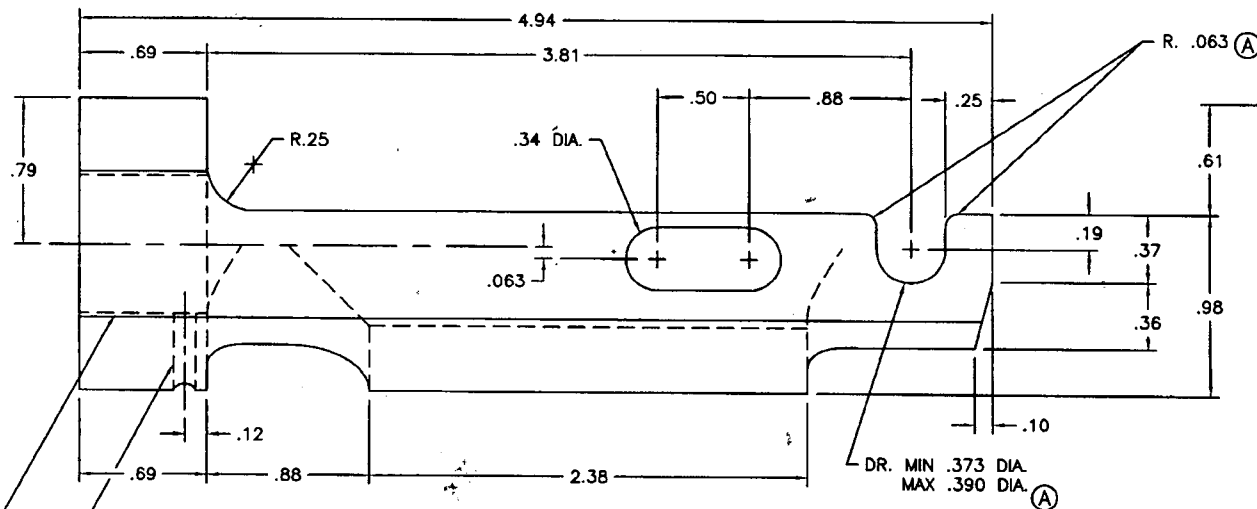
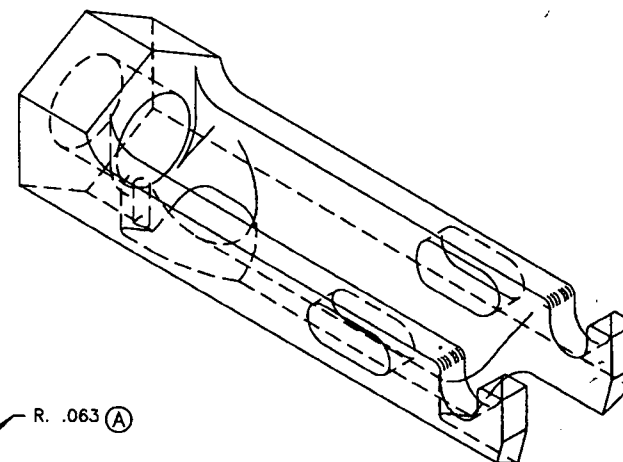
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
070402	7.0	Parts were modified Per Mil-A-8625F1-Type I-Class 2 Per QSI 017, instead of PAS Per Dwg, Mil-A-8625-Type III-Class 2	 07.04.13	Parts are acceptable per eng. approval. As Per Bill. 		 070402	 as per QSI 048 07.04.13	 070402

NOTE: Date & initial all entries



REVISION					
LETTER	DFTSMAN	DATE	DESCRIPTION	APPROVED	DATE
A	DNN	2/17/03	ADDED SMOOTH EDGES TO -001 & -003; REDUCED LENGTH OF -003 BY .125"; ADDED DRAIN HOLE TO -001; INCREASED DIA. OF AFT SLOT ON -001.		
			MINOR CHANGE - FAR 21.95	CHECK	D. MURPHY
					2/17/03



DR. .12 DIA. DRAIN HOLE
(NOTE: SPOTFACE IF REQ'D
TO DRILL HOLE)

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NO. 31019

3/4"-20 THD.

ANODIZE IN ACCORDANCE WITH MIL-A-8625, TYPE III, CLASS 2
DYED BLACK.

NOTE:

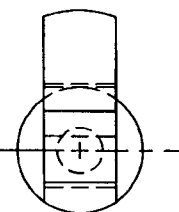
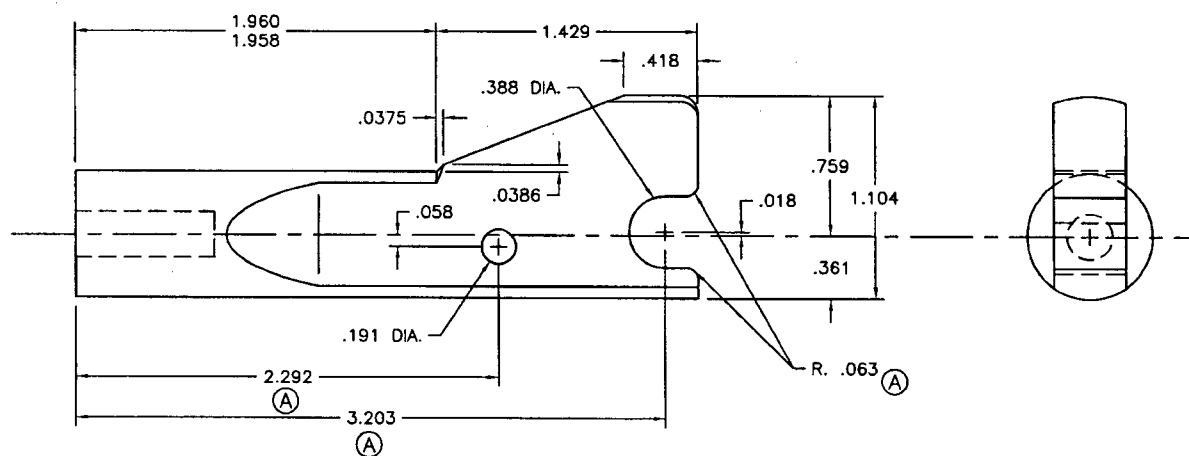
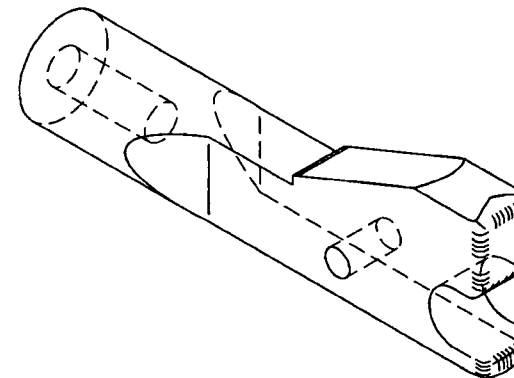
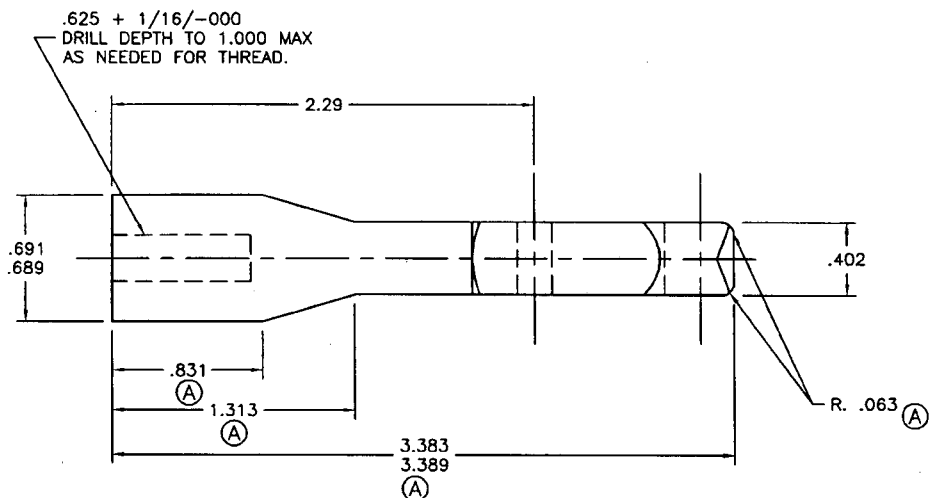
-001 TUBE

1	MS21209F4-15	INSERT							
	-005	PIVOT ARM	△	1.00 DIA. x 3.56	2024-T4, T351 ALUM.				
	-003	LATCH	△	1.11 x 3.50	2024-T4, T351 ALUM.				
	-001	TUBE	△	1.38 HEX STK. x 4.94	2024-T4, T351 ALUM.				
	-005	PART NO.	NAME	STOCK SIZE	MATERIAL	MATL SPEC	ZONE		
LIST OF MATERIAL									
NO. REQ'D PER ASSY									
PROPRIETARY RIGHTS NOTICE									
UNLESS OTHERWISE SPECIFIED									
X.2.1									
XX.2.03									
XXX.2.010									
ANGLES ±.1/2"									
2									
41232-200-001									
NEXT ASSEMBLY									
MIL									
DRAFTSMAN									
CHECK									
STRESS									
PROD. ENGR.									
HEAT TREAT									
FRESH									
DRAFTSMAN		D. NELSON	2/18/02	TITLE					
CHECK		D. MURPHY	2/18/02	STEP ACTUATOR COMPONENTS					
STRESS									
PROD. ENGR.									
HEAT TREAT									
FRESH									
DWG. NO.		41232-200-002				SCALE		2:1	
SHT 1 OF 3									
REV.		A							

Eva Aviation, Inc.

41232-200-002
SHT 1 OF 3

A



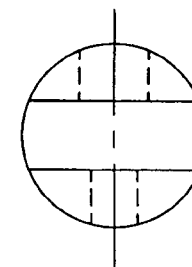
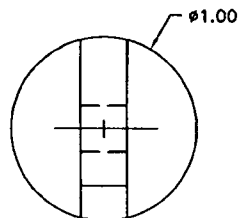
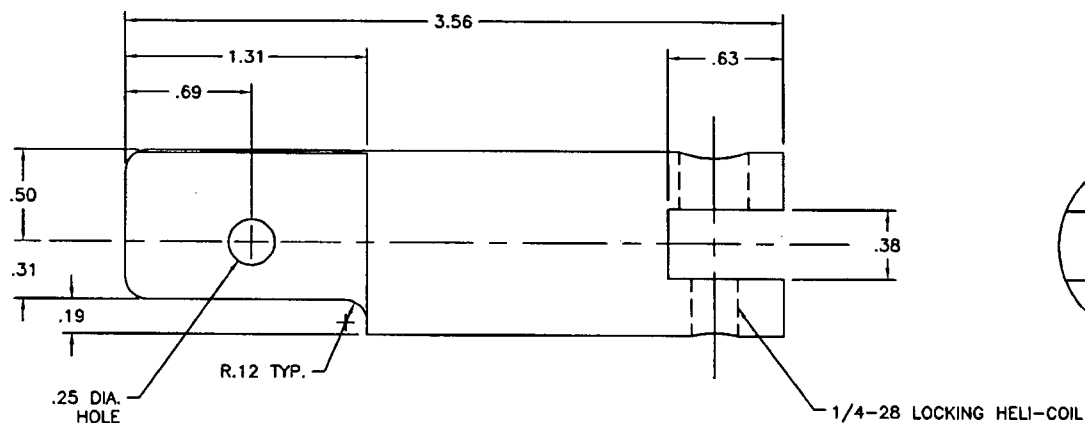
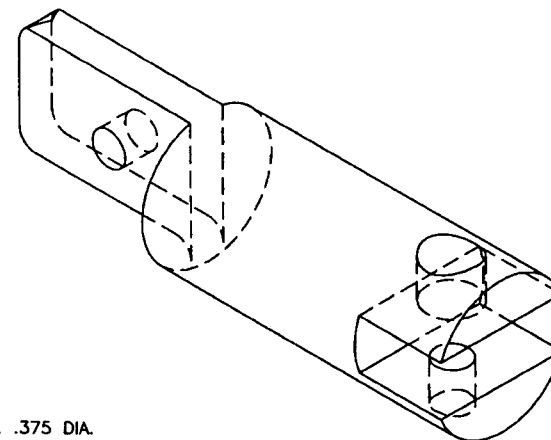
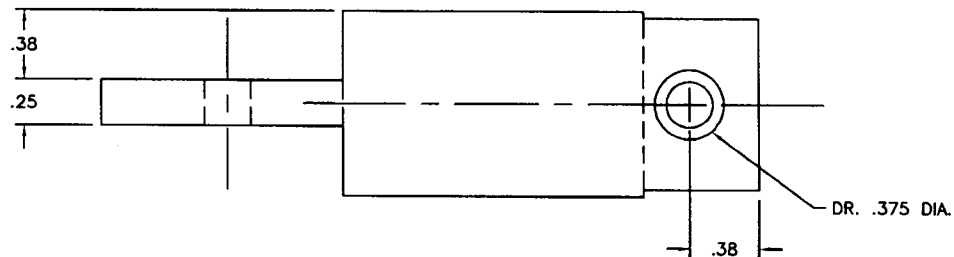
-003 LATCH

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Era Aviation, Inc.

TITLE	SIZE	DWG. NO.	REV.
STEP ACTUATOR COMPONENTS	C	41232-200-002 SHT 2 OF 3	A



-005 PIVOT ARM

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Era Aviation, Inc.

TITLE
STEP ACTUATOR COMPONENTS

SIZE
C

DWG. NO.
41232-200-002
SHT 3 OF 3

REV.
A

DATE 2/26/04	ENGINEERING ORDER	E.O. No. B-1	SHT. 1 OF 1
BY D. NELSON		DWG. AFFECTED 41232-200-002	
APPROVED BY		SHEET AFFECTED SHT 1 & 3	
TITLE STEP ACTUATOR COMPONENTS			

REASON FOR CHANGE: CHANGED DASH NO. OF INSERT ON L/M; CHANGED INSERT CALLOUT ON -005 PIVOT ARM.

MINOR CHANGE - FAR 21.95

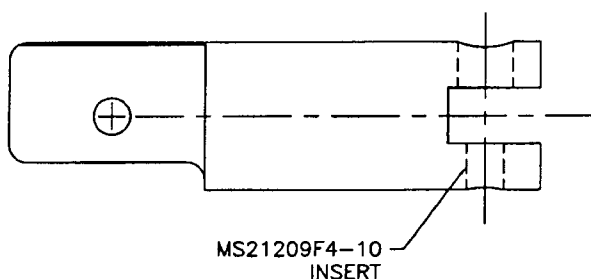
IS

1	MS21209F4-10	INSERT
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WAS

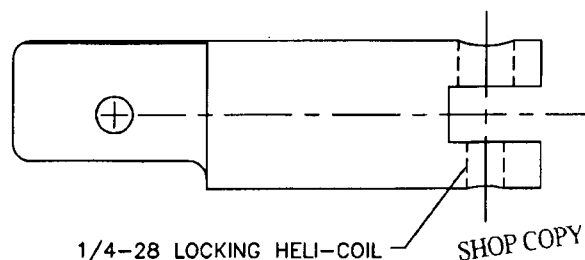
1	MS21209F4-15	INSERT
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IS



-005 PIVOT ARM

WAS



-005 PIVOT ARM

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CHANGE REQUIRED:	DATE:	BY:	YES	NO
TRAVELER				
INSTALLATION INSTRUCTIONS				
MAINTENANCE INSTRUCTIONS				
ILLUSTRATED PARTS				
UNINCORPORATED DRAWING LIST				
MASTER DRAWING LIST				
COMPUTER DATA BASE				

DART AEROSPACE LTD		Work Order:
Description: <i>TUBE</i>		Part Number: <i>41232-200-002-00 J</i>
Inspection Dwg:	Rev: <i>A</i>	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
<i>1.38</i>	<i>+/-0.30</i>	<i>1.375</i>	<i>-</i>			
<i>1.13</i>	<i>+/-0.30</i>	<i>1.127</i>	<i>-</i>			
<i>.88</i>	<i>+/-0.30</i>	<i>.876</i>	<i>-</i>			
<i>4.94</i>	<i>+/-0.30</i>	<i>4.940</i>	<i>-</i>			
<i>3.81</i>	<i>+/-0.30</i>	<i>3.807</i>	<i>-</i>			
<i>.690</i>	<i>+/-0.30</i>	<i>.690</i>	<i>-</i>			
<i>.690</i>	<i>+/-0.30</i>	<i>.691</i>	<i>-</i>			
<i>.88</i>	<i>+/-0.30</i>	<i>.878</i>	<i>-</i>			
<i>.12</i>	<i>+/-0.30</i>	<i>.128</i>	<i>-</i>			
<i>.50</i>	<i>+/-0.30</i>	<i>.500</i>	<i>-</i>			
<i>.25</i>	<i>+/-0.30</i>	<i>.257</i>	<i>-</i>			
<i>.37</i>	<i>+/-0.30</i>	<i>.369</i>	<i>-</i>			
<i>.98</i>	<i>+/-0.30</i>	<i>.983</i>	<i>-</i>			
<i>.373-.390</i>		<i>.374</i>	<i>-</i>			
<i>2.38</i>	<i>+/-0.30</i>	<i>2.380</i>	<i>-</i>			
<i>.34</i>	<i>+/-0.30</i>	<i>.340</i>	<i>-</i>			
<i>Ø.12</i>	<i>+ .005 - .000</i>	<i>.125</i>	<i>-</i>			

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:
Date: <i>07-03-20</i>	Date: <i>07-03-20</i>	Date:

Rev	Date	Change	Revised by	Approved
<i>A</i>		<i>New Issue</i>	<i>KJ/RF</i>	

TNM**ANODISATION et PEINTURE TNM INC.**

21 chemin de l'Aviation, QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / ISO 9001-2000 certified

Certifié NADCAP / NADCAP certified

**PACKING
SLIP****54032**

23-Mar-2007

CLIENT / CUSTOMER:**DART AEROSPACE LTD.**

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

**PURCHASE ORDER/
NO. DE COMMANDE:****00003360**

1	9	9	41232-200-002-003	B31020
2	13	13	4123-200-002-005	B31021
3	13	13	41232-200-002-001	B31019

*CP 03/27***PICKED UP BY / RECU:** _____

En cas de perte ou de dommages dû a la la valeur intrinsèque de certaines responsabilité se limitera à deux fois la valeur du traitement des pieces perdues ou endommagées.

Due to the intrinsic value of some parts, we are only liable for loss or damage to twice the invoiced finishing costs.

TNM

ANODISATION et PEINTURE TNM INC.

C. OF C

21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

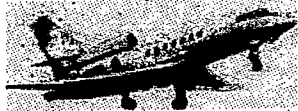
Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 / AS9100 certified

approuvé NADCAP approved

54032

23-Mar-2007



CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY, ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE

PURCHASE ORDER/
NO. DE COMMANDE: 00003360



1	9	9	41232-200-002-003 B31020	REV: A BLACK ANODIZE PER MIL-A-8625F1 TYPE I CLASS 2
2	13	13	4123-200-002-005 B31021	REV: A BLACK ANODIZE PER MIL-A-8625F1 TYPE I CLASS 2
3	13	13	41232-200-002-001 B31019	REV: A BLACK ANODIZE PER MIL-A-8625F1 TYPE I CLASS 2

REQUIREMENTS HAVE BEEN IN ACCORDANCE WITH MD-INC P.R.I.D.E. MANUAL

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.
Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.
Travel cards have been filed and are available for viewing upon request.

Signature/Signed: _____

☐ Directeur de la Qualité / Q.A. Manager ☐ ☐

